

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022239**Date Inspected:** 25-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Bay 1

This QA inspector observed ZPMC in process of SMAW welding on Re-Built traveler rail 20TR2 assemblies and Bike Path Handrail sub-assemblies. ZPMC CWI inspector Tian Lei was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 3 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

WR20481

Weld- 20TR2-036-011

WPS-345-SMAW-1G(1F)-Repair

Welder- 049769

1G/SMAW/CJP

WR20481

Weld- 20TR2-044-009, 20TR2-037-009

WPS-345-SMAW-1G(1F)-Repair

Welder- 054467

1G/SMAW/CJP

Weld- Bike Path Handrail sub-assemblies

WPS-B-P-2112

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## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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Welder- 215248  
2F/SMAW

### Bay 8

This QA inspector observed FCAW (ESAB) welding on Saddle Housing SH3003, SH3001, SH3007 assemblies. ZPMC QC inspector Liu Chuan Gang was present at this time of this observation and informed this QA inspector of the work that is in process and identified Lin Za Wen as the CWI. It was stated that ZPMC had 3 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- SH3003-001-001, 003, 005, 007  
WPS-B-T-2132-ESAB  
Welder-054459  
2F/FCAW

Weld- SH3001-002-003, 005, 007, 009  
WPS-B-T-2132-ESAB  
Welder-500479  
2F/FCAW

Weld- SH3007-002-002, 004, 006  
WPS-B-T-2132-ESAB  
Welder-500405  
2F/FCAW

### Bay 10

This QA inspector observed ZPMC in process of SMAW welding on traveler rail, cantilever beam assembly and heat straightening. ZPMC CWI inspector Li Jun was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 4 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- 28TR1-009  
WPS-B-T-2212-TC-U4c  
Welder- 040365  
2G/SMAW/CJP

WR20489  
Weld- BK17B-001-017  
WPS-345-SMAW-1G(1F)-Repair  
Welder- 057258  
1G/SMAW/CJP  
Cantilever Beam Assembly

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## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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WR20475

Weld- 37TR2-009

WPS-345-SMAW-2G(2F)-Repair

Welder- 040582

2G/SMAW/CJP

HSR1 (B) 10226

BK16

Cantilever Beam Assembly

Bay 11

This QA inspector performed FCAW (ESAB) welding on Bike Path assembly BK004A1-059 and heat straightening on traveler rail 20TR2. ZPMC QC Wang Chuang Xui was present at this time of this observation and informed this QA inspector of the work that is in process and identified Xu Le Feng as the CWI. This QA inspector verified this information for the following location;

Weld- BK004A1-059-008, 038

WPS-B-T-2132-ESAB

Welder- 205649

2F/FCAW

HSR1 (B) 10131

20TR2-035

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

“As noted within the contents of this report.”

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hasler, Mike	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley, Ken	QA Reviewer

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